	er ID 125599 ber 16, 2014 8:44:07 AM		*12!	5599*							Page	1
Item ID: Revision ID:	D3575-2		Accept	*N900	040	100)*	Setup		*N	S1*	
Item Name:	Cargo Floor Protector								Stop	*N	S2*	
Start Date:	10/16/14 Start Qty: 2.0	0 *2*		Cust Item I	D:							
Required Date:	10/17/14 Req'd Qty: 2.0	⁰⁰ *2*		Customer:								
Reference:								_	G			
Approvals:	Process Plan:	Date: 14.10.16	Tooling:	Da	ate:				Start	*N	R1*	
	QC:	Date:	SPC (Y/N):	Da	ate:				Stop	*N	R2*	
Sequence ID/ Work Center II	Operation D Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reje Qty		Reject Number	Insp. Stamp	
Draw Nbr	Revision Nbr											
D3575	Rev A											
100			0.00				_				//	1
100	FLOW WATER JE	Τ	0.00				<u> </u>			DC	14/10/1	<u>'</u>
Waterjet FLOW CNC Waterj		XTURE SIDE UP*** as per Dwg D3575	0.00							PT		>
	Dwg R	ev: A										
	Prog R	ev:A										
	2-Debu	ırr						_		•		
110	QC2- Inspect parts	off machine FAI/FAIB	0.00					//	per parametrica.			
*11 0 *	Мето		0.00				_3_	-(DK/	19/10/19	4

Quality Control

DQA:	<u>,</u>	AWI	. Date:	14/1	2/08								NA PT
(Ź	À		1, 1, 1	0	, , (WORK ORDER NON	-C(ONFO	RMANCE / U				AEROSPACE
QA Closed:	<u> 2</u> [/	Me	_ Date:	14/	12/	4				W	ork Order up	odate only	
Work Orde	er:	125	559	33		DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
	•	_				Rework]		Skid-tube	Crosstube		Water Jet 🕰	Engineering
Part N	No.	D39	575	-2		Scrap 🔊	-		Machining	Small Fab	Pro	d. Eng. Coor.	Quality
						Use-as-is		Thermoforming Finishing Rec/Store/Packaging					Other
NCR 1	۱٥.	14-4	342			Suspected Unapproved]		Large Fab	Composite	j	Supplier	
Root			<u>-</u>		Desci	ription of work order update		nitial	Act	ion	Sign &		
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descr	ription	Date	Verification	QC Inspector
Design				,	60	t ups all scratch blogge didn't son before t		DAS	SCAP /	destrax		DAS	
Doc/Data	\dashv	14-10-18	100	/	the	t was all scratch		16 9-89	scrap/	-1	14/10/23	38	DAS
Equip/Tooling									and r	esaer	14/10/23	9-89	16 9-89
Handling/Pre	\dashv				EP	player didn't see before	60	2042				007 0 0 0041	
Material Operator	7				cu	7	الدي ا	10123				OCT 2 3 2014	aszarz
Offset/Setup	+						191	(10/2)		0			14/10/23
Process	\vdash				RC	. Mandling naturals Revery material Belove			_	1.62			1
Supplier	\Box					2 1			l de (2	ξ(·Ψ			
Training					110+ j	knesty material Balose			d a				
Transport					cutto	Y. '							
Unapproved													
							FAL	JLT CAT	regory				
Landi	ng G	iear			_	General		1			ī	_	_
		Bending			ļ	Bend	<u> </u>		rogram		Outside Dim		Pressure/Forced
		Centre No	ot Concer	ntric	-	BOM/Route	<u> </u>	Grain			Over/Under		Set-up
	\dashv	Cracks				Broken/Damage/Defect	<u> </u>	Hardwa		├	Part Incorred	 	Temperature/Cure
	Crimp/Kink/Ripple/Wave Burrs					<u> </u>		ion Incomplete/Ur	· · · · · · · · · · · · · · · · · · ·	Part Lost/Mi	· ·	Weld	
	Cuffs Contamination					\vdash		ions Incomplete/U		Part Moved		Wrong Stock Pulled	
Crushing Countersink				<u> </u>	_	ned/off center		Positioned W]			
Heat Treat Cut Too Short					\vdash	Mislabe			Power Loss/S	Surge	Other		
Inspection Strip in Tube Drawing Marks/Chatter Drill Holes						Misread Off-set	ז						
Turning Sequence Finish					\vdash		Calibration						
		Wave/Tw				Fit/Function	\vdash		Sequence				
	l	wave/ iw	ist in Tub	e,		Fit/Function	L	Out of S	sequence				

Work	Order II	125599
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125599 Page 2 Thursday, October 16, 2014 8:44:07 AM Accept Setup Start Item ID: D3575-2 *N900040100* **Revision ID:** Stop Cargo Floor Protector **Item Name:** *9* Start Qty: 2.00 **Cust Item ID: Start Date:** 10/16/14 Req'd Oty: 2.00 Required Date: 10/17/14 *9* **Customer:** Reference: Start Run **Tooling:** Process Plan: Date: Date: Approvals: Stop QC: Date: SPC (Y/N): Date: Tool # Plan Reject Reject Set Up/ Tool ID Accept Insp. Sequence ID/ **Operation** Code Qty **Qty** Number Stamp Work Center ID Description **Run Hours** DAS QC8- Inspect parts - second check 0.00 120 38 *120* 9-89 0.00 QC OCT 2 3 2014 Memo Quality Control 0.00 Identify as per dwg & Stock Location: 150 OCT 3 1 2014 *150* Packaging 0.00 Memo Packaging QC21- Final Inspection - Work Order Release 0.00 160 *160* OC 0.00 Memo **Quality Control**

DQA: Date:					WORK ORDER NON-CONFORMANCE / UPDATE									
QA Closed:		Date:			WORK ORDER NON	-C(ONFO	RMANCE / U		Wc	ork Order uj	odate only		AEROSPACE
Work Orde	er:				DISPOSITION				AGAINST I	DEI	PARTMENT	/PROCESS	•	
Part N	lo.				Rework Scrap Use-as-is Suspected Unapproved		Machining Small Fall Thermoforming Finishing		Crosstube Small Fab Finishing Composite	Prod. Eng. Rec/Store/Pack		Water Jet d. Eng. Coor. re/Packaging Supplier		Engineering Quality Other
Root				Desci	ription of work order update		Initial	Ac	tion		Sign &			
Cause	Date	Step	Qty		or non-conformance	Ch	nief Eng	Desc	ription		Date	Verification	۱	QC Inspector
Design Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier Fraining Fransport Unapproved							-							
Juapproved 1				<u> </u>		FAI	ULT CAT	EGORY		1				
Landir	ng Gear				General		021 071	20011.			·			
	Bending Centre No Cracks Crimp/Kin Cuffs Crushing Heat Trea Inspectio Marks/Ch	nk/Ripple at n Strip in natter	/Wave		Bend BOM/Route Broken/Damage/Defect Burrs Contamination Countersink Cut Too Short Drawing Drill Holes Finish		Grain Hardwa Inspecti Instruct Misalig Mislabe Misread Off-set	on Incomplete/U ions Incomplete/I ned/off center led	· -		Outside Dim Over/Under Part Incorred Part Lost/Mi Part Moved Positioned W Power Loss/S	tolerance ct ssing Vrong		Pressure/Forced Set-up Temperature/Cure Weld Wrong Stock Pulled Other
Turning Sequence Wave/Twist in Tube				Fit/Function		4	equence		-					

Picklist Print

Thursday, October 16, 2014 8:44:13 AM

Work Order ID: 125599

125599

Parent Item:

D3575-2

D3575-2

Parent Item Name: Cargo Floor Protector

Start Date: 10/16/14

Required Date: 10/17/14

Start Qty: 2.00

Required Qty: 2.00

Comments:

IPP Rev : A New Issue 07-01-22 EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.125-F60029-04		Purchased	No			100	sf	5,896.686	8	19			/ /
*MI FXS 1 GE PLASTICS LEXAN SH		029-04	*						**			DC 14/1	0/18

Location	Loc Oty	Loc Code	
MAT019	1590.095		
124866	106		***
m126425	160.925		
m127934	665		Mart
m128746)	658.17		(32)
SABIC	2560		
m130209	2560		
TPI	1746.59178		
m129759	1746.59178		

DQA:	Date:				WORK ORDER NON-CONFORMANCE / UPDATE								DART
QA Closed:		Date	:		WORK ORDER NON	-((JINFO	RIVIAINCE / C	PDATE	W	ork Order up	odate only	AEROSPACE
Work Orde	· ·				DISPOSITION				AGAINST	DE	PARTMENT,	/PROCESS	
Work Orde	er				Rework	1		Skid-tube	Crosstube		1	Water Jet	Engineering
Part N	10.				Scrap			Machining	Small Fab	-	Prod. Eng. Coor.		Quality
NCR N	10				Use-as-is Suspected Unapproved		Thermoforming Large Fab		Finishing Composite		Rec/Store/Packaging		Other
TTCKT					Suspected Ollapproved	ا				L	j	Supplier	
Root				Descr	iption of work order update	ı	nitial		ction		Sign &		
Cause	Dat	e Step	Qty		or non-conformance	Ch	ief Eng	Desc	cription		Date	Verification	QC Inspector
Design	_												
Doc/Data													
Equip/Tooling													
Handling/Pre Material													
Operator	_												
Offset/Setup												i ·	
Process													
Supplier													: '
Training			}										i a
Transport								·					
Unapproved								·					
				<u> </u>		FAL	JLT CAT	EGORY			· · · · · · · · · · · · · · · · · · ·		
Landir	ng Gear				General								<u> </u>
	Bendi	ng			Bend		Folio/P	rogram			Outside Dim	ensions	Pressure/Forced
	Centre	Not Conce	entric		BOM/Route		Grain				Over/Under	tolerance	Set-up
	Cracks				Broken/Damage/Defect		Hardwa	re			Part Incorred	ct	Temperature/Cure
	Crimp	Kink/Rippl	e/Wave		Burrs		Inspecti	on Incomplete/U	Inqualified		Part Lost/Mi	ssing	Weld
	Cuffs				Contamination		Instruct	ions Incomplete/	'Unclear		Part Moved		Wrong Stock Pulled
	Crushi			-	Countersink			ned/off center		-	Positioned W		
	Heat T				Cut Too Short	-	Mislabe				Power Loss/	Surge	Other
	—	tion Strip ir	1 Tube		Drawing	-	Misread	I					
	_	/Chatter			Drill Holes	_	Off-set					· · · · · · · · · · · · · · · · · · ·	
		Finish	_	1	Calibration								
Wave/Twist in Tube				Fit/Function	L	Out of S	equence						

DART AEROSPACE LTD	Work Order:	125599
Description: Cabin Floor Protector	Part Number:	D3575-2
Inspection Dwg: D3575 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

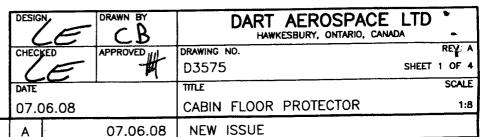
X	First Article	Pro	ototype
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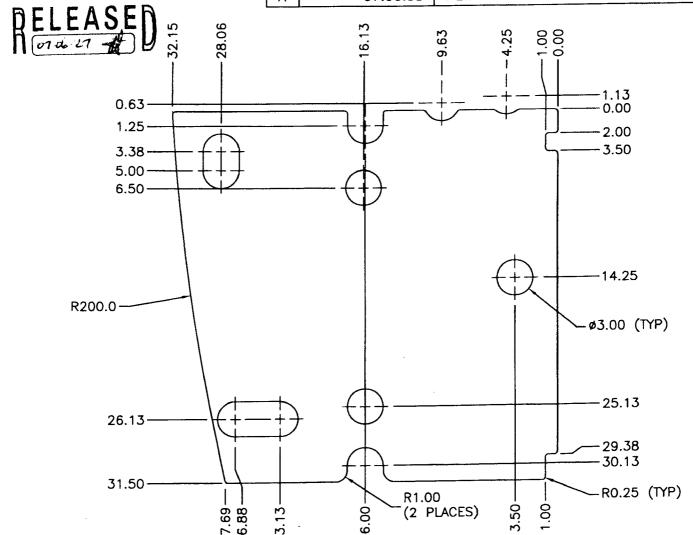
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø3.00	+0.006/-0.001	3.00	_		V=JKM-01	
1.00	+/-0.030	1.00	/		12JKM-06	
3.50	+/-0.030	350	/			
16.00	+/-0.030	16.00	-			
23.13	+/-0.030	23.13	/			
26.88	+/-0.030	26.84	/			
27.69	+/-0.030	27.69	/			
4.25	+/-0.030	4.25	/			
9.63	+/-0.030	9.63				
16.13	+/-0.030	16.13	/			
28.06	+/-0.030	28.06				
32.15	+/-0.030	32.15	/			1-4-50
2.00	+/-0.030	2-00				
3.50	+/-0.030	3.50				
14.25	+/-0.030	14.25	_			
25.13	+/-0.030	25.13	_			
29.38	+/-0.030	29.34	/			
30.13	+/-0.030	30.13	/			
1.25	+/-0.030	1.25				
3.38	+/-0.030	3.38	/			
5.00	+/-0.030	5.00	1			
6.50	+/-0.030	6.50				
26.13	+/-0.030	26.13	-			
31.50	+/-0.030	31.50	DAS			

Measured by:	De	Audited by:	9- 89	Prototype Approval:	N/A
Date:	14/10/14	Date:	DCT 2 2 2044	Date:	N/A
Pov Doto	Change		UC. 7 3 71116	Povised by	Approved

1	Rev	Date	Change	Revised by∧	Approved
	Α	08.02.29	New Issue	KJ/DD 🛠	
				· · · · · · · · · · · · · · · · · · ·	•







D3575-1 CABIN FLOOR PROTECTOR (SHOWN) D3575-2 CABIN FLOOR PROTECTOR (OPPOSITE)

NOTES:

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3575-1/-2" USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) CHECK PER TEMPLATE DT8966

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